

Date: Monday, 1/23/2006 7:51:33 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET, CLEVIS
Job Number	: 25581		
Estimate Number	: 10109		
P.O. Number	: N/A	Part Number	: D2012115
This Issue	: 1/23/2006	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Number	: D2012-115 REV. A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24559	Drawing Revision	: A
Written By	: See Comment Below		
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est: A 02.09.20 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: 621 Laser cut as per Dwg D2012-115 (Note: 2 parts) Material release note required
2.0	D2012115F	Bracket,Clevis
		Comment: Qty.: 1.0000 Each(s)/Unit Total 50.0000 Each(s) BRACKET, CLEVIS
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK Inspect dimensions per template D2012-115T1 & T2
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, CLEVIS

Job Number: 25581

Part Number: D2012115

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2012-115 and bend Jig D2012-115T1

SB 06/03/21

1 parts
1 part has 115
1 parts less 119

7.0 QC5

INSPECT WORK TO CURRENT STEP



J 06.03.22

Comment: INSPECT WORK TO CURRENT STEP

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Mel Fauteux

06/04/07

Hermine M. 06-05-02

40

P0

Comment: WELD INSPECTION

Inspect weld and completeness on the W/O

9.0 QC5/9

WELD INSPECTION



J / A 06/05/10 (111)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S717

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Ruth 10 (111)

Comment: DOCUMENT CONTROL

Inspection Level 21

11.0 DC

DOCUMENT CONTROL



(111) 06/05/15

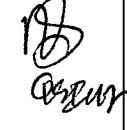
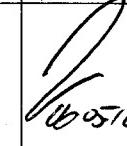
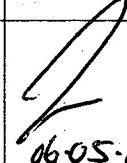
Job Completion



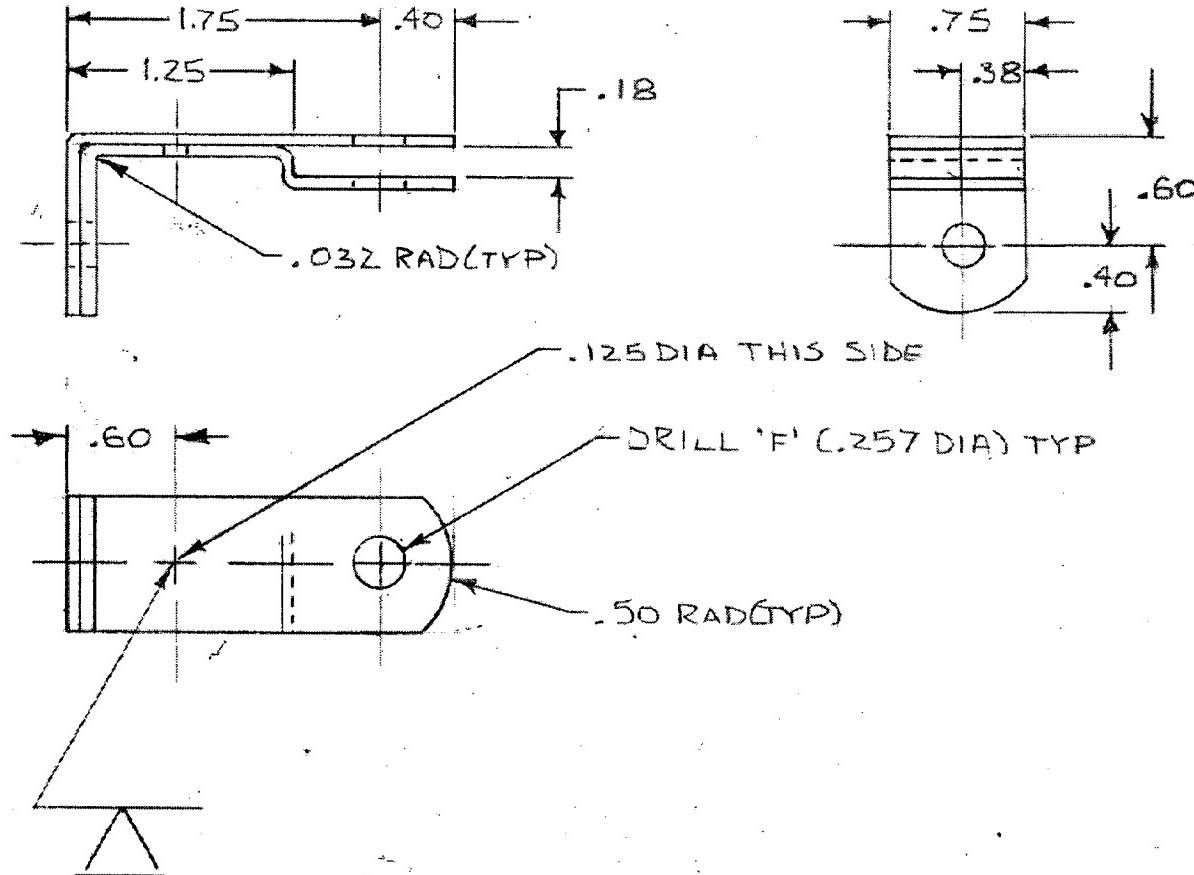
U Donnell

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/15
 QA: N/C Closed: _____ Date: _____

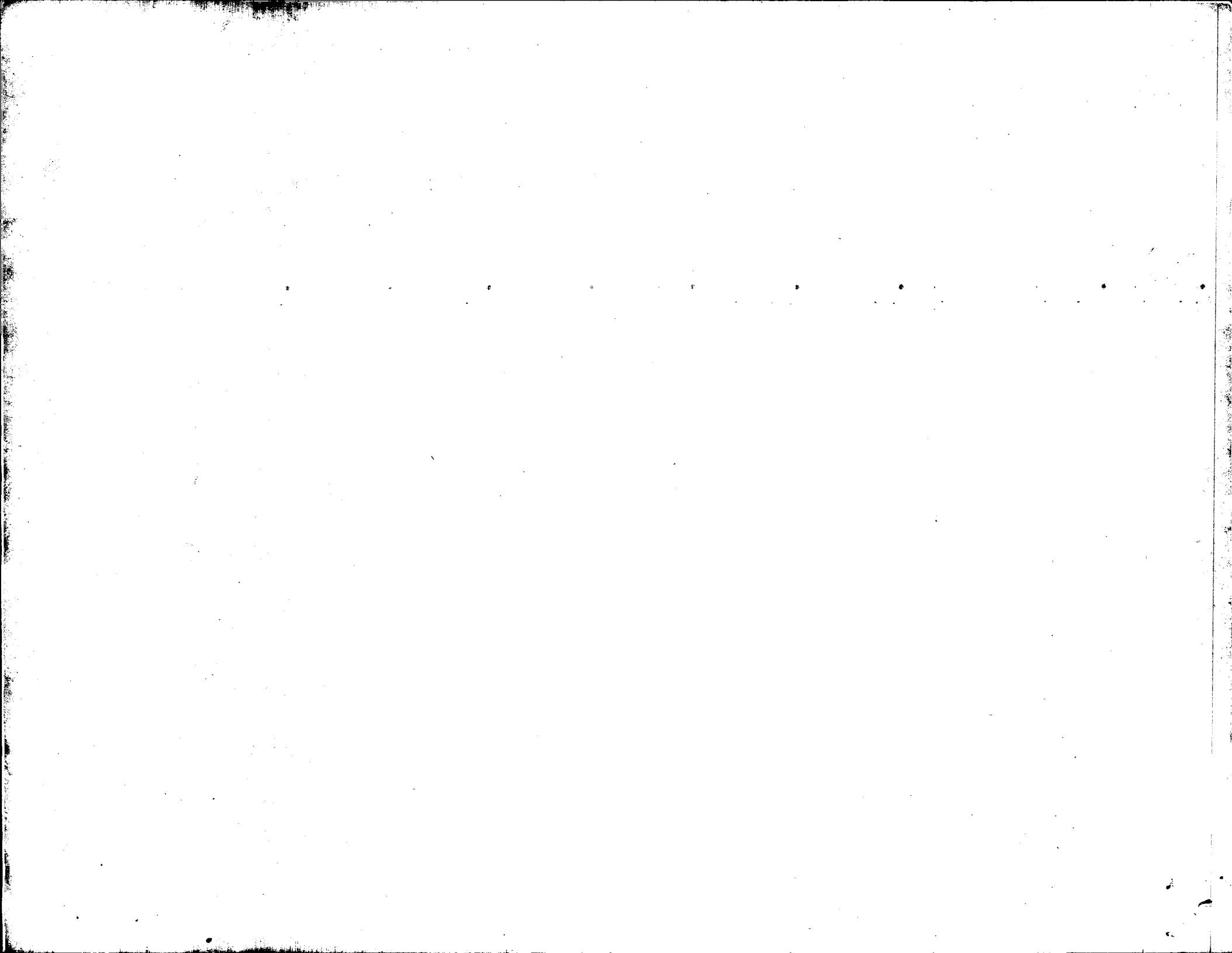
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/10	8	5 parts no good. Holes misaligned, had (2), and 3 were ground to much. Employee's first time.	 06/05/10	Scrap: destroy.	 06/05/10	 06/05/10	 06/05/10	 06/05/10

NOTE: Date & initial all entries



NOTES: 1. MAT'L AISI 304/316 CRES
.063 THICK

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.			RIVET CODE SHALL BE PER NAS 523	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	DRAWN				BASIC CODE	DIA. DASH NO. HEXHEAD REAR SIDE HEXHEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA	
	APPROVED				ONIMPLE DIGITIMO OF SHEETS COUNTERSINK	LENGTH DASH NO. MSP-SPN-HELD	HATTON	DATE		
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED			BASIC CODES		BRADLEY	74/3/1	TITLE	
		GENERAL		UNITS		64-M5104 FOAD 88-M2042KAO	STRESS	BRACKET		
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS #114 3. REMOVE SHARP EDGES 0.05 MAX 4. THICKNESS OF MUL. S. .7545 5. HOLES PER AND TOLRNT 6. SYMMETRY ABOUT ALL MPC CENTRE LINES .005		TOLERANCES - .005 & .030 .005 & .010 2 ANGLES 1 N° 1 FLAT SURF 4 ECCENTRICITY 5 SYMMETRY ABOUT ALL MPC CENTRE LINES .005		CHECKED	BRADLEY	Dwg No	DZ012-115	REV
		REPORT ALL DISCREPANCIES - DO NOT SCALE			CLIENT		SEAL	FULL	S-1	OF 1





NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 185045 02

Mail To:

ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:

ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Steel: 304

Finish: 2B

160314

Your Order: V033868

NAS Order: AE 0249852 03

Corrosion: ASTM A263/01E, 180 Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTM A240/01, A480/01, A666/00, ASME SA240/01, SA480/01, SA666/01
QQ-S766D-A X MG PRM, AMS 5513G X MRK&FIN, MIL 5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940 120.0000	SHEET	8	42

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG % -2"	Hard RB	Tail H Tail
A96138	0415N6	F T	96.06	19.79	43.68	85.00	89.00

P.O. 621